

Work Order ID 67750

Wednesday, March 30, 2011 9:05:09 AM

PRELIMINARY ISSUE



Page 1

Item ID: D4330-2

Accept



Setup Start



Revision ID:

Item Name: Airframe Bracket

Stop



Start Date: 3/30/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/31/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

H

Date: *11-03-30*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4330	PA <i>3</i>								
100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg (made from D4330-1)								
<i>661. 063</i>	Dwg Rev: <i>PA8</i>								
	Prog Rev: <i>PA9</i>								
	2-Deburr if necessary								
110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									
120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

B11-3-30

3

B11-3-30

-inspector is PA8

Day only

En 10/30

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Start Date: 3/30/2011 Start Qty: 1.00

Required Date: 3/31/2011 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Bend as per dwg
NC BRAKE

0.00

Brake NC

Memo

0.00

Brake NC

Sp 11/03/30

③

140

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

- inspected to PAB
Dry only

Sp 11/03/30

③

150

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

x3 0 11/03/30

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Page 3

Item ID: D4330-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Airframe Bracket

Start Date: 3/30/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/31/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
155 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo POWDER COAT: Start Time: _____ Oven Temperature: _____ Finish Time: _____	0.00 0.00							
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							
170 Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							

Ergle
R4 1370

11/3/2011

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 4

Item ID: D4330-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Airframe Bracket

Start Date: 3/30/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/31/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

661103.30

POSITIVE RECALL

EFFECTIVE 11-03-30 AUTH

RELEASED _____ DATE _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Wednesday, March 30, 2011 9:05:15 AM

Work Order ID: 67750

Parent Item: D4330-2

Parent Item Name: Airframe Bracket


Start Date: 3/30/2011

Required Date: 3/31/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.03.17 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No			100	sf	41.0000	0.265	0.278947			
													
6061-T6 .063 Sheet													



B11-3-30

Location

Loc Qty

Loc Code

MAT021

41

113608

5

116308

36

113608

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Preliminary use only

DART AEROSPACE LTD		Work Order: 67750
Description: Air Frame Bracket RH		Part Number: D4330-2 (Bent)
Inspection Dwg: D4330	Rev: PAE	Page 1 of 1

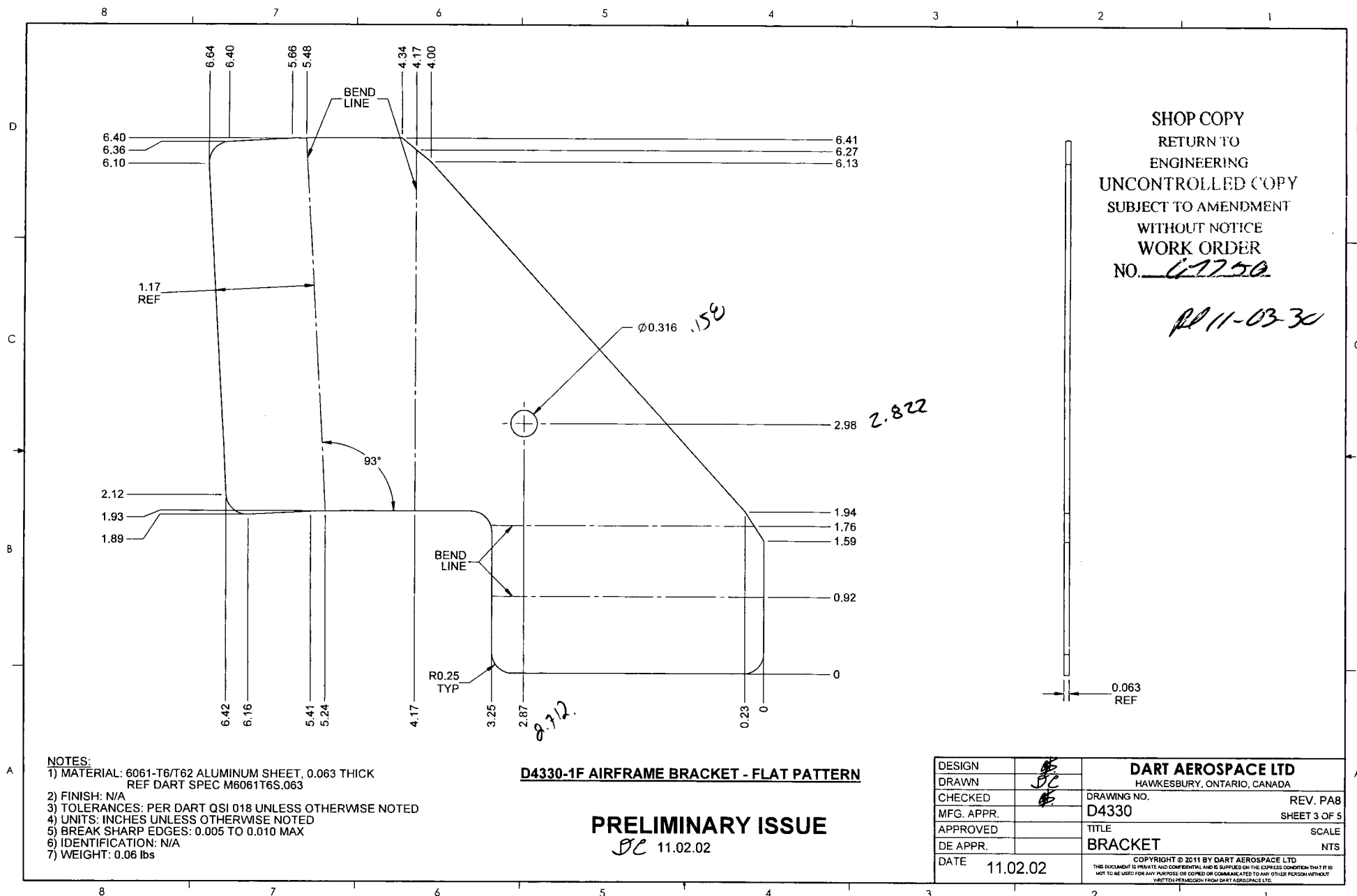
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.66"	±.030	5.666"	✓		Vern ED-0526	
5.44"	±.030	5.442"	✓		Vern ED-0526	
0.94"	±.030	.943"	✓		Vern ED-0526	
0.19" (Ref)	±.030	0.19"	✓		Vern ED-0526	
1.25	±.030	1.247	✓		Vern ED-0526	
2.019 (typ)	±.030	0.19	✓		Rtg	
1.00	±.030	0.985	✓		Vern ED-0526	
1.00	±.030	1.006	✓		Vern ED-0526	
1.23	±.030	1.218	✓		Vern ED-0526	
1.47 (Ref)	±.030	1.459	✓		Vern ED-0526	
3°	± 1/2°	3°	✓		Bevel Protmchr ED-0526	

Measured by: SD	Audited by: S	Prototype Approval:	N/A
Date: 11/03/30	Date: 11/03/30	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 67750

PL 11-03-30

NOTES:
1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
REF DART SPEC M6061T6S.063

2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.06 lbs

D4330-1F AIRFRAME BRACKET - FLAT PATTERN

PRELIMINARY ISSUE

SC 11.02.02

DESIGN		DART AEROSPACE LTD	
DRAWN	<i>SC</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>SC</i>	DRAWING NO.	REV. PA8
MFG. APPR.		D4330	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	11.02.02	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

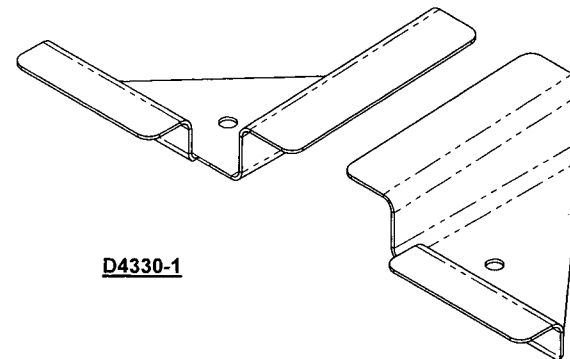
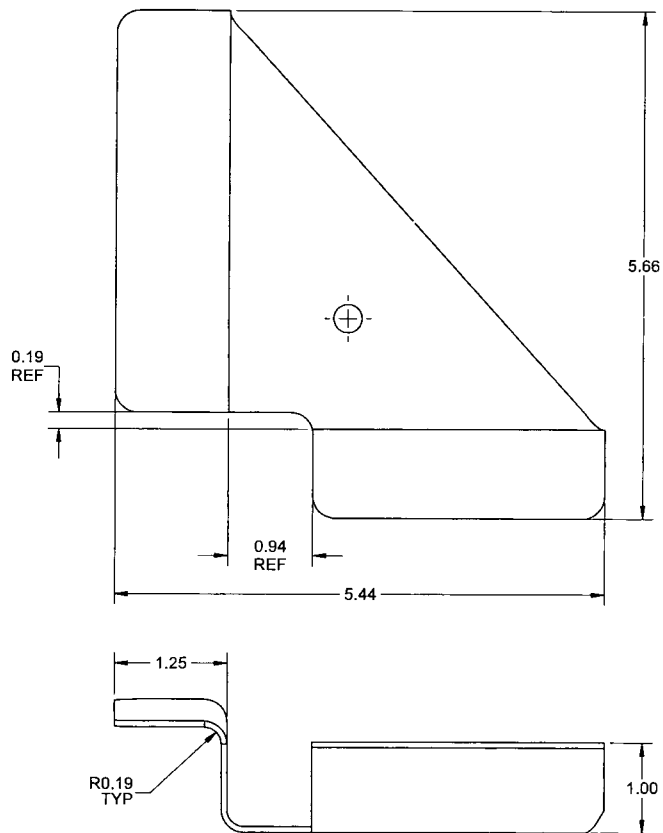
W/O:		WORK ORDER CHANGES					
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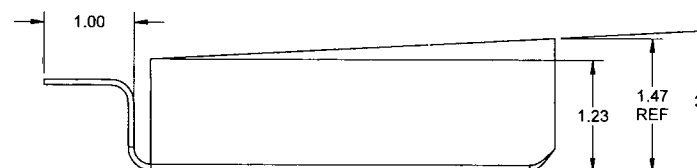
NOTE: Date & initial all entries



D4330-1

D4330-2

u/c 67752



D4330-2 AIRFRAME BRACKET, RH
D4330-1 AIRFRAME BRACKET, LH (OPPOSITE)

NOTES:

- 1) MATERIAL: MADE FROM D4330-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.06 lbs

PRELIMINARY ISSUE

BC 11.02.02

DESIGN	BC	DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BC	DRAWING NO.	REV. PA8
MFG. APPR.		D4330	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Linda Lacelle

From: Daniel Campbell <dcampbell@dartaero.com>
Sent: March 29, 2011 4:37 PM
To: 'Linda Lacelle'; 'Brad Jones'
Subject: D4330-2 Bracket

Hi,

Linda, can you please make qty. 1 D4330-2 bracket (RH)? It does not need to be finished or painted. The D4330-PA8 dwg is in the prelim folder and I have updated the ~~dxf~~ for the -1/-2.

Brad, can you please prepare a PO if required?

47750

Thanks,

Daniel Campbell
Mechanical Engineer
DART Aerospace Ltd.

P: 403-717-0325

F: 403-717-1288

E: dcampbell@dartaero.com

W: www.dartaero.com

M: 1060 McTavish Road, NE, Calgary, Alberta, T2E 7G6

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